

Work Order ID 71656 -1

Thursday, July 07, 2011 12:06:58 PM



Ship today

Page 1

Item ID: D3564-3

Revision ID:

Item Name: Wearshoe

Start Date: 7/7/2011

Start Qty: 12.00

Required Date: 7/21/2011

Req'd Qty: 12.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

CL

Date: 11/07/07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

Draw Nbr

Revision Nbr

D3564

Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ***** (D3564-14) ***** Dwg Rev: *D* Prog
Rev: *D* 2-Deburr if necessary

B11-8-2

(14)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-8-2

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/03

(14)

Work Order ID 71656

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Item ID: D3564-3

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 7/7/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

0.00



Brake NC

NC BRAKE

Memo

0.00

Brake NC

Deburr if necessary: Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 Form Joggle as per Dwg D3564 on brake using Jig DT8157

JB 11/03/11 14

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

Ensure joggle as per dwg D3429

5/10/11

(414)

150

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Qty Description Batch A/R 2059B Hardcoat
m118953 Weld hardcoat as per Dwg D3437

X4

11-08-11 JBL / 11-08-11

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Page 3

Item ID: D3564-3

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 7/7/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

8 u/08/11

QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

8 u/08/11

QC

Memo

0.00

Quality Control

(+4)

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

117338

Powdercoat

Memo

0.00

8 u/08/11

Powder Coating

START TIME:

1:00pm

OVEN TEMPERATURE:

1:30pm

FINISH TIME:

320°

Work Order ID 71656

Thursday, July 07, 2011 12:06:58 PM

Page 4

Item ID: D3564-3

Accept

Revision ID:

Item Name: Wearshoe

Setup Start

Stop

Start Date: 7/7/2011 Start Qty: 12.00

Required Date: 7/21/2011 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: FP-1

0.00

Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/8/11 [Signature]

4 of 11 11/08/11

MF "07-17

Picklist Print

Thursday, July 07, 2011 12:06:56 PM

Page 1

Work Order ID: 71656

Parent Item: D3364-3

Parent Item Name: Wearshoe



Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-03-08 ec
 IPP Rev:B As per Rev C 07-07-09 JLM
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA



304/316 Sheet .063

Purchased

No

100

sf

15.1000

1.1

13.89474

18.5



Bill-8-2

Location

Loc Qty

Loc Code

MAT020

15.1

117275

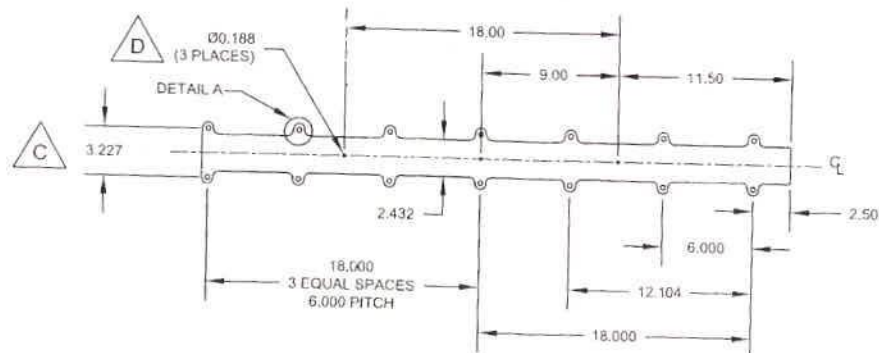
1.7

117653

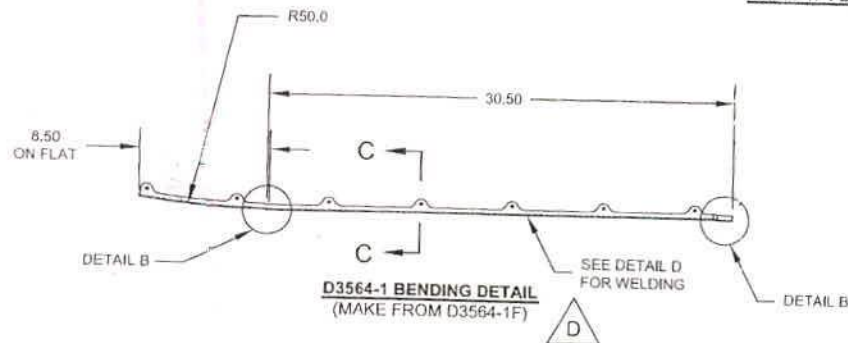
13.4

117275

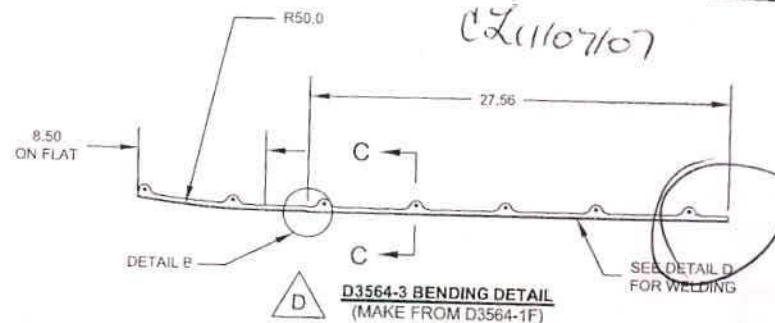
(A)



D3564-1F FLAT PATTERN



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5, C5: ADD D3564-15; PG1 B6, B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ON PG1; PG3 B8, C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5, 7, B2: RELOCATE DETAILS AND SECTION; PG3 A5, 7, B2: INCREASE DETAIL AND SECTION SIZE		CB	07.08.21
	C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
	B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
	A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION		BY	DATE
DESIGN	PH			
DRAWN	CB			
CHECKED	PH			
MFG. APPR.	PH			
APPROVED	PH			
DE APPR.	PH			
DATE	07.08.21			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3564
TITLE WEARSHOE
SCALE 1:8
REV. D
SHEET 1 OF 3

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RELEASED

07.09.04

716.54
CL1107107

DART AEROSPACE LTD		Work Order:	71656
Description: Wearshoe		Part Number:	D3564-3
Inspection Dwg: D3564	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.230	✓		V Bo2	
2.432	+/-0.010	2.436	✓		V	
2.50	+/-0.030	2.497	✓		V	
6.000	+/-0.010	6.000	✓		T Bo1	
12.104	+/-0.010	12.104	✓		T	
18.000	+/-0.010	18.000	✓		T	
18.000	+/-0.010	18.000	✓		T	
18.00	+/-0.030	18.00	✓		T	
9.00	+/-0.030	9.00	✓		T	
11.50	+/-0.030	11.50	✓		T	
0.300 x 0.300	+/-0.010	0.297 x 0.296	✓		V	
Ø0.188	+0.005/-0.001	0.188	✓		V	
R0.375	+/-0.010	0.375	✓		R.G	
0.063	+/-0.010	0.060	✓		V	

Measured by: B
Date: 11-8-2

Audited by: S
Date: 11/08/03

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	
B	08.09.04	Dwg Rev updated	KJ/DD	